

Work Order ID 74685-2

Wednesday, October 05, 2011 9:58:35 AM



Page 1

Item ID: D3602-1

Revision ID:

Item Name: Angle

Start Date: 10/5/2011 Start Qty: 20.00

Required Date: 10/11/2011 Req'd Qty: 20.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3602

Rev B

100



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

I-Cut as per Dwg D3602
Deburr if necessary

Dwg Rev:

0.00

Prog Rev:

-2-

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5 units

10/10/21
724

10/10/21

10/10/26

Work Order ID 74685

Wednesday, October 05, 2011 9:58:35 AM



Item ID: D3602-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 10/5/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Form as per Dwg D3602

Sp 11/11/21

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sp 11/11/21

(X2)

150

0.00



Identify as per dwg & Stock Location: 241A

Packaging

Memo

0.00

Packaging

aluber sp 11/11/21

Work Order ID 74685

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Item ID: D3602-1

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Item Name: Angle

Start Date: 10/5/2011 Start Qty: 20.00

Required Date: 10/11/2011 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

11/11/21 *[Signature]*

mf
11-11-21

Fast Print

Wednesday, October 05, 2011 9:58:31 AM

Page 1

Work Order ID: 74685

Parent Item: D3602-1

Parent Item Name: Angle



Start Date: 10/5/2011

Required Date: 10/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-27 JLM
IPP Rev:B 08-12-11 as per FCN08-577 DID verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	147.0795	0.585	12.31579			



304/316 .040 Sheet



12.31579

Location

Loc Qty

Loc Code

MAT020

147.0795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

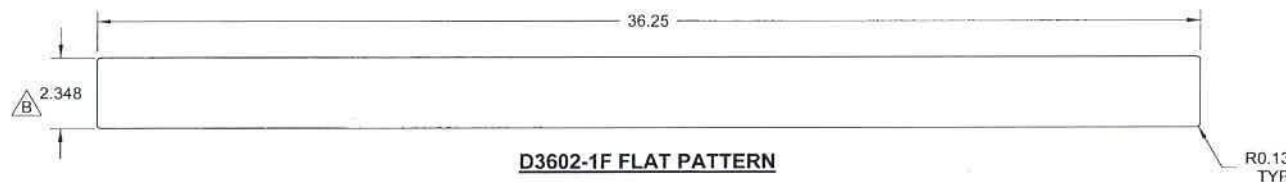
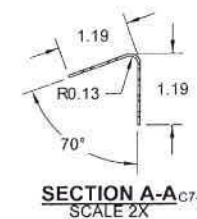
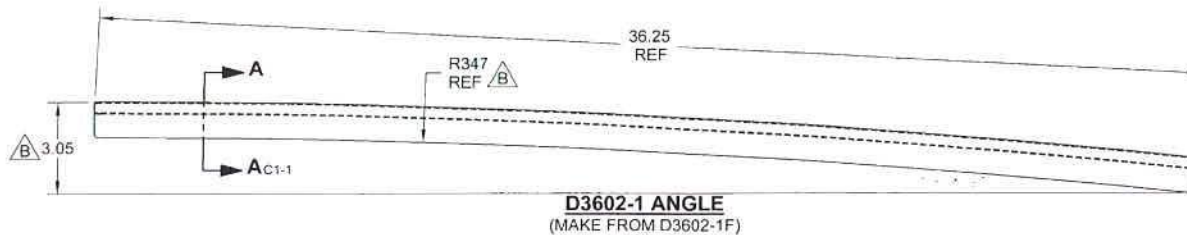
118964

59.5

118964



REFERENCE ONLY



RELEASED
01/03/11 MB

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs

#74685

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3602
TITLE ANGLE
SCALE NTS
REV. B
SHEET 1 OF 1
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